



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2724-042
Job Sheet 167758



Part No: D2724-042

Job Qty: 2 ea

Part Name: 206L Step Assembly, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 11/6/17

Job Tracking No:

Due Date: 11/5/17

Created By: Victoria Michaud-Febrille

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		11/4/17	0.00	0.00	Start Up Large Fab2		SL 11/7/17
100	Large Fab	2 pcs		11/4/17	0.00	1.67	Large Fab 8		SL DAS 11/7/17
105	QC	2 pcs		11/4/17	0.00	0.00	QC5		38
110	Large Fab	2 pcs		11/4/17	0.00	1.67	Large Fab 2		S.L 11/8/17
120	QC	2 pcs		11/4/17	0.00	0.00	QC9		17-11-09
130	QC	2 pcs		11/4/17	0.00	0.00	QC5		2017-11-13-25C
140	HandFinish	2 pcs		11/4/17	0.00	0.46	HandFinish1		PD 17-11-13
150	QC	2 pcs		11/4/17	0.00	0.00	QC7		SL 11/14/17
160	Large Fab	2 pcs		11/4/17	0.00	1.67	Large Fab 2		DAS 38
170	QC	2 pcs		11/4/17	0.00	0.00	QC10		38 9-89
180	QC	2 pcs		11/4/17	0.00	0.00	QC5		2017-11-15-25C
190	HandFinish	2 pcs		11/4/17	0.00	0.46	HandFinish1		BR 17-11-17
200	Powdercoat	2 pcs		11/4/17	0.00	0.30	Powdercoat1		15
210	QC	2 pcs		11/4/17	0.00	0.00	QC3		12/11/20
220	HandFinish	2 pcs		11/5/17	0.00	0.46	HandFinish3		DEB 2017/11/20
230	QC	2 pcs		11/5/17	0.00	0.00	QC3		9-89
240	Packaging	2 pcs		11/5/17	0.00	0.00	Packaging3		5m/B
250	QC21-SA	2 Ea		11/5/17	0.00	0.00	QC21		DEC 04 2017

Part Op 100 - Cut D2724-2 using D2622 extrusion as per Dwg D2724 Deburr and bevel ends for welding

Descriptions: 110 - Weld end cap (One End Only) and lugs as per Dwg D2724 using Jig DT10074

160 - 1- DRILL AND C/SINK HOLE BEFORE WELDING AS PER DWG(DEF)

200 - START TIME: 10:05 FINISH TIME: 10:05 A.T. 320°

250 - DRILL VENT HOLE AS PER SECTION A-A

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2622-120C 162484-2	2	12	0	0
110-Large Fab	D2734 164510	2	14	0	0
	D3458-1 5002358	4	18	0	0
	D3458-3 B166312	4	9	0	0
	MS20601-AD4W2FM13836-72	2	113	0	0
160-Large Fab	D2734	2	14	0	0

Part Specifications

Work Order:		Part No.		NCR No.		Date:	
DISPOSITION		Suspected Unapproved		Use-as-is		Rework	
Skid-tube		Machining		Thermoforming		Large Fab	
Cross tube		Small Fab		Finishing		Composite	
Water Jet		Prod. Eng. Coord.		Rec/Store/Packaging		Supplier	
Engineering		Quality		Other			
MRB (QS1042) Approval		Completed By		Lead hand / Supervisor		Approval Verification	
QC / QA Coordinator		Approval					
Root Cause		Operator		Offset/Set		Supplier	
Training		Use for Testing		Poor Information		Rushing	
Product Improvement		Wave/Twist in Tube		Masks/Chatter		Drill Holes	
Instructions Incomplete/Unclear		Cut Too Short		Countersink		Out of Sequence	
Misaligned/off center		Misread		Turning Sequence			
Misidentified		Past Expiry Date		Substation		LOA	
Tribal Knowledge		Internal Transport		Material		Handling/Pre	
Equipment/Tooling		Doc/Data		Design		Environment	

DART
AEROSPACE
S007094



206L Step Assembly, RH

PART NO: D2724 – 042
Revision:
Operation: Large Fab
Change No:

Mfg Date: 11/06/17
Job No: 167758

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com